

Work Order ID 150494***150494***

Page 1

Wednesday, August 24, 2016 12:39:07 PM

Item ID: D3883-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, Outside RH

Start Date: 9/6/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 9/12/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

DAS
21
9-89

Date: AUG 30 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3883

D

100

0.18

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.66

HAAS CNC vertical machine #1

Program Batch No. 150494

Double check by: JFL

1-Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA817 and inspect per Dimension Sheets

110

0.00

110

QC

Quality Control

QC1- Inspection performed by CMM

Memo

0.01

Inspect on CMM as per folio CMM A013.

DWG REV:

CMM PROG. REV:

DAS
14
9-89

16/09/14

DAS
14
9-89

16/09/14

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective : 240 12				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition 3 38.5					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : _____			

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Item ID: D3883-2 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Saddle, Outside RH
Start Date: 9/6/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 9/12/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.02				6	0		DAS 45 9-89
Quality Control									2016-9-14
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.12							
Hand Finishing									(x6) 2016/09/15 BER.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
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		OTHER :																							

Work Order ID 150494

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150494

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Item ID: D3883-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Outside RH
 Start Date: 9/6/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 9/12/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140 Powdercoat Powder Coating	Memo <i>m 125418.</i> ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)*** ***DO NOT MASK INSIDE FLANGE SURFACE*** START TIME: <i>8:55</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>9:25</i>	0.03				<i>6</i>	<i>φ</i>	<i>16-09-20</i>	<i>34 9-89</i>
150	QC3- Inspect Part Finish	0.00							
150 QC Quality Control	Memo	0.01				<i>6</i>			<i>DAS 38 9-89</i>

SEP 20 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order update only ☐

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Work Order ID 150494***150494***

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Wednesday, August 24, 2016 12:39:07 PM

Item ID: D3883-2**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Saddle, Outside RH**Start Date:** 9/6/2016 **Start Qty:** 6.00***6*****Cust Item ID:****Required Date:** 9/12/2016 **Req'd Qty:** 6.00***6*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160

Identify as per dwg & Stock Location: 36401

0.00

160

Packaging

Memo

0.01

Packaging

6 SEP 20 2016DAS
6
9-89

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.10

Quality Control

DAS
21
9-89 SEP 21 2016DAS
21
9-89 SEP 20 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Picklist Print

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Page 1

Work Order ID: 150494

150494

Parent Item: D3883-2

D3883-2

Parent Item Name: Saddle, Outside RH

Start Date: 9/6/2016

Required Date: 9/12/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
15.05.20 remove inside powdercoat DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-015

Manufactured No

Each 37.0000

6

D6101-015

Saddle Billet

Location

Loc Qty

Loc Code

MAT045

37

144955

37

6

only 12/09/13

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order update only ☐

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Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																				
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																				
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																				
OTHER : _____																																																																							

DART AEROSPACE LTD		Work Order:	150 494
Description: Saddle, Outboard, RH		Part Number:	D3883-2
Inspection Dwg: D3883 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		2.875
B	1.433	1.443		1.438	1.438	1.438	1.438		1.438
C	0.638	0.658		.648	.648	.647	.648		.648
D	3.895	3.905		3.900	3.900	3.900	3.900		3.900
E	0.257	0.262		.259	.259	.259	.259		.259
F	0.605	0.625		.614	.615	.614	.615		.615
G	1.120	1.130		1.125	1.125	1.125	1.125		1.125
H	2.245	2.255		2.250	2.250	2.250	2.250		2.250
I	2.000	2.020		2.000	2.000	2.000	2.000		2.000
J	0.140	0.165		.150	.146	.146	.147		.146
K	0.240	0.260		.247	.247	.247	.247		.247
L	0.115	0.135		.127	.127	.127	.126		.126
M	0.140	0.165		.147	.148	.147	.147		.148
N	0.720	0.780		.760	.760	.764	.764		.760
O	0.240	0.260		.249	.252	.251	.253		.250
P	0.110	0.140		.140	.140	.140	.140		.140
Q	0.178	0.198		.188	.188	.188	.188		.188
R	2.825	2.885		2.855	2.855	2.855	2.855		2.855
S	0.316	0.321		.316	.316	.316	.316		.316
T	0.990	1.010		.999	1.000	1.000	1.000		1.000
U	1.745	1.755		1.750	1.750	1.750	1.750		1.750
V	5.990	6.010		6.000	6.000	6.000	6.000		6.000
W	1.245	1.255		1.250	1.250	1.250	1.250		1.250
X	0.490	0.510		.501	.500	.501	.500		.500
Y	1.220	1.280		1.250	1.255	1.255	1.255		1.250
Z	2.495	2.505		2.500	2.500	2.500	2.500		2.500
AA	0.313	0.318		.314	.315	.315	.315		.315
AB	0.020	0.040		.030	.030	.030	.030		.030
AC	0.760	0.765		.765	.765	.765	.765		.765
AD	0.215	0.220		.219	.219	.219	.220		.218
AE	1.265	1.285		1.265	1.265	1.265	1.265		1.265
AF									
Accept/Reject							DAS		

Measured by:	amr
Date:	16/09/14

Audited by:	45
Date:	2016-9-14

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	AA

DART AEROSPACE LTD		Work Order:	150494
Description: Saddle, Outboard, RH		Part Number:	D3883-2
Inspection Dwg: D3883 Rev. D		Page 1 of 1	

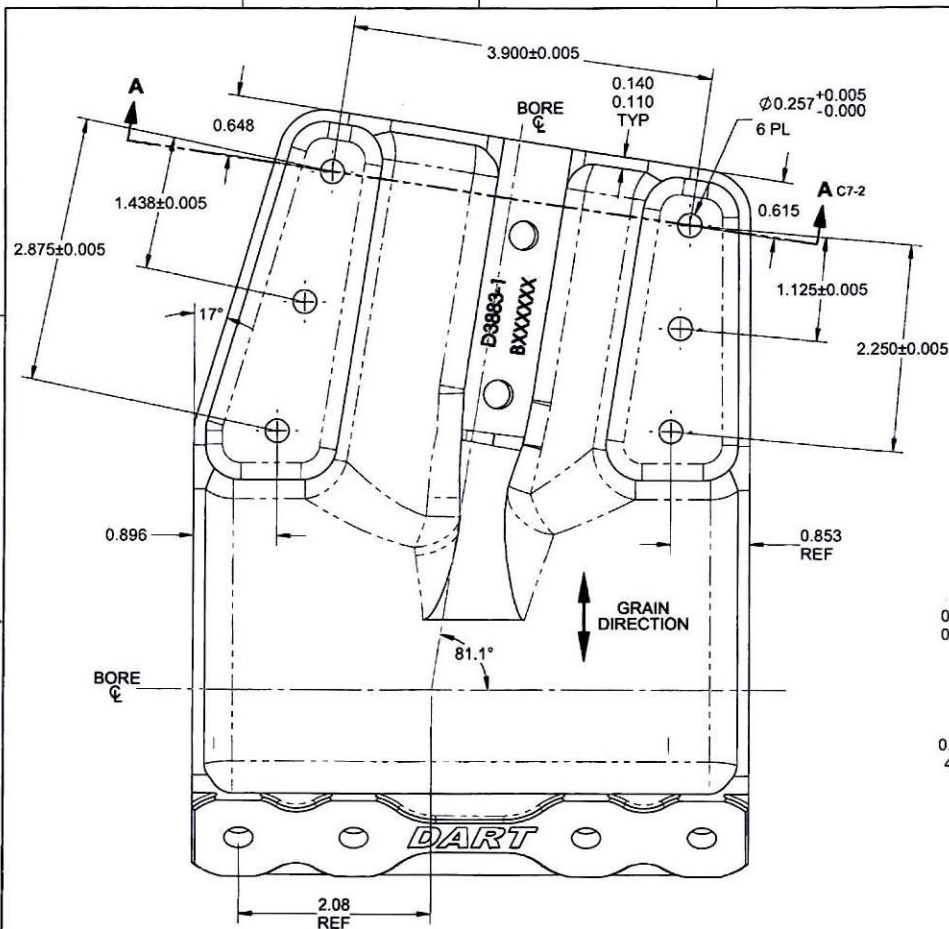
Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	2.870	2.880		2.875					
B	1.433	1.443		1.438					
C	0.638	0.658		.648					
D	3.895	3.905		3.900					
E	0.257	0.262		.259					
F	0.605	0.625		.614					
G	1.120	1.130		1.125					
H	2.245	2.255		2.250					
I	2.000	2.020		2.000					
J	0.140	0.165		.146					
K	0.240	0.260		.247					
L	0.115	0.135		.126					
M	0.140	0.165		.148					
N	0.720	0.780		.760					
O	0.240	0.260		.252					
P	0.110	0.140		.140					
Q	0.178	0.198		.188					
R	2.825	2.885		2.855					
S	0.316	0.321		.316					
T	0.990	1.010		1.000					
U	1.745	1.755		1.750					
V	5.990	6.010		6.000					
W	1.245	1.255		1.250					
X	0.490	0.510		.500					
Y	1.220	1.280		1.250					
Z	2.495	2.505		2.500					
AA	0.313	0.318		.314					
AB	0.020	0.040		.040					
AC	0.760	0.765		.765					
AD	0.215	0.220		.220					
AE	1.265	1.285		1.265					
AF									
Accept/Reject							DAS 45		

Measured by:	<i>[Signature]</i>
Date:	16/09/14

Audited by:	9-89
Date:	2016-9-14

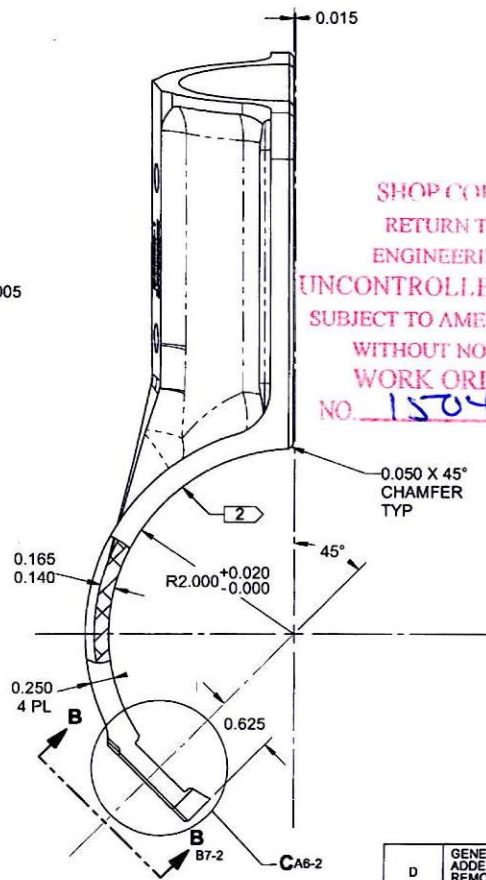
Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	<i>[Signature]</i>



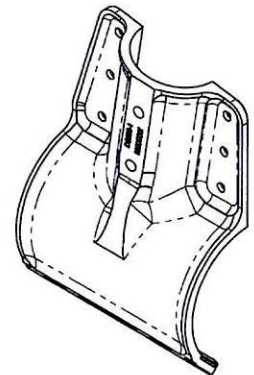
D3883-1 SADDLE, OUTBOARD LH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-1-REVD.SLDPRT"



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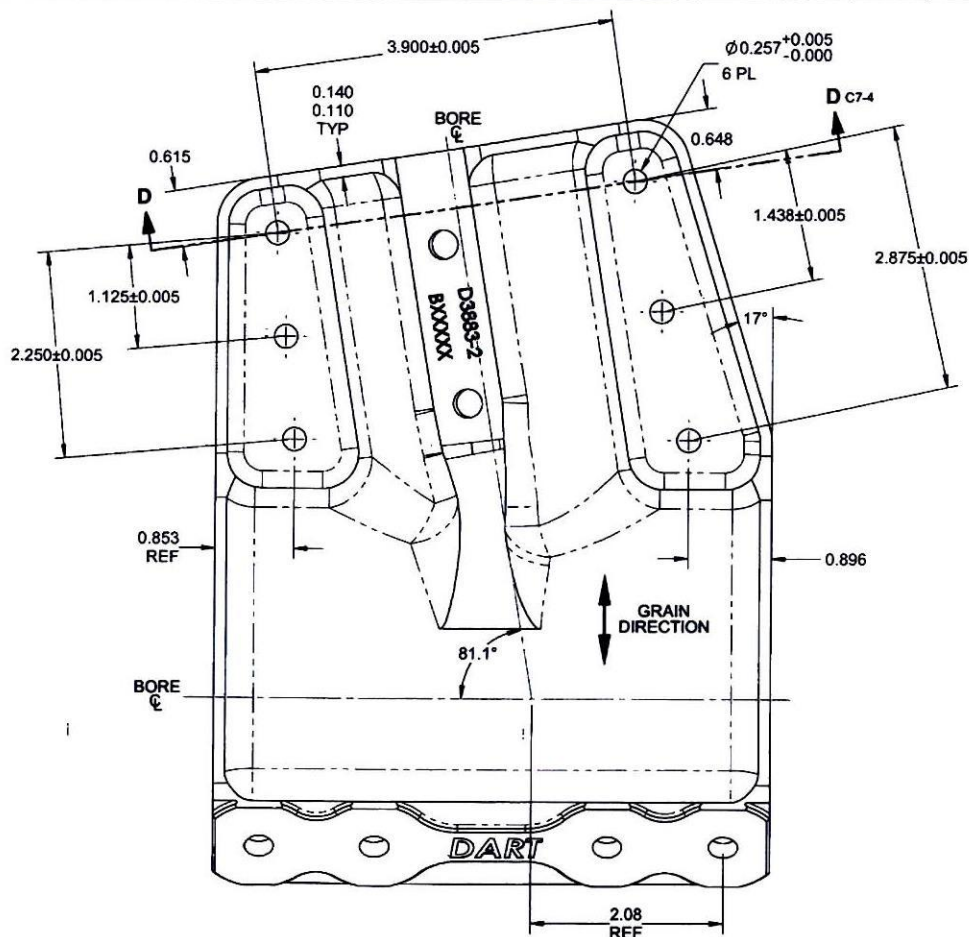


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2015 MAY 19
A.P. Ecn15-575

D	GENERAL REDRAW. ADDED D3883-2 ON SHEETS 3 & 4. ADDED NOTE 9 & REMOVED UNNECESSARY DIMS. REMOVED POWDER COAT ON INSIDE SURFACE OF D3883-1/-2	AP	15.02.11
C	ADD R1.265 (ZN D6-2)	RF	09.11.09
B	D6101-015. ZN A7-1; ADD 0.648. ZN D7-1; ADD 0.615. ZN D6-1; ADD 0.125. ZN D7-2; ADD 0.060 & R0.031. ZN B5-2; 0.75 WAS 0.728. ZN C7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO. D3883	
MFG. APPR.	JLM		
APPROVED	HS	TITLE OUTBOARD SADDLE	
DE APPR.	D3		
DATE	15.02.11	REV. D SHEET 1 OF 4 SCALE NTS	

APPROVED

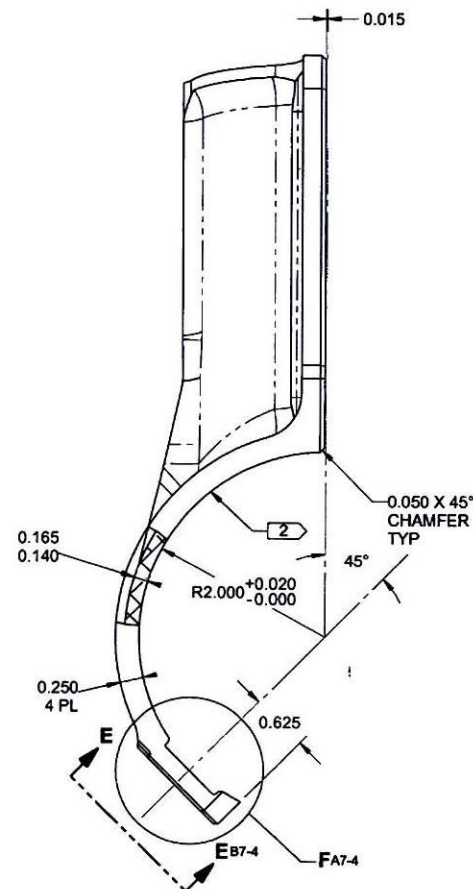
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D3883-2 SADDLE, OUTBOARD RH

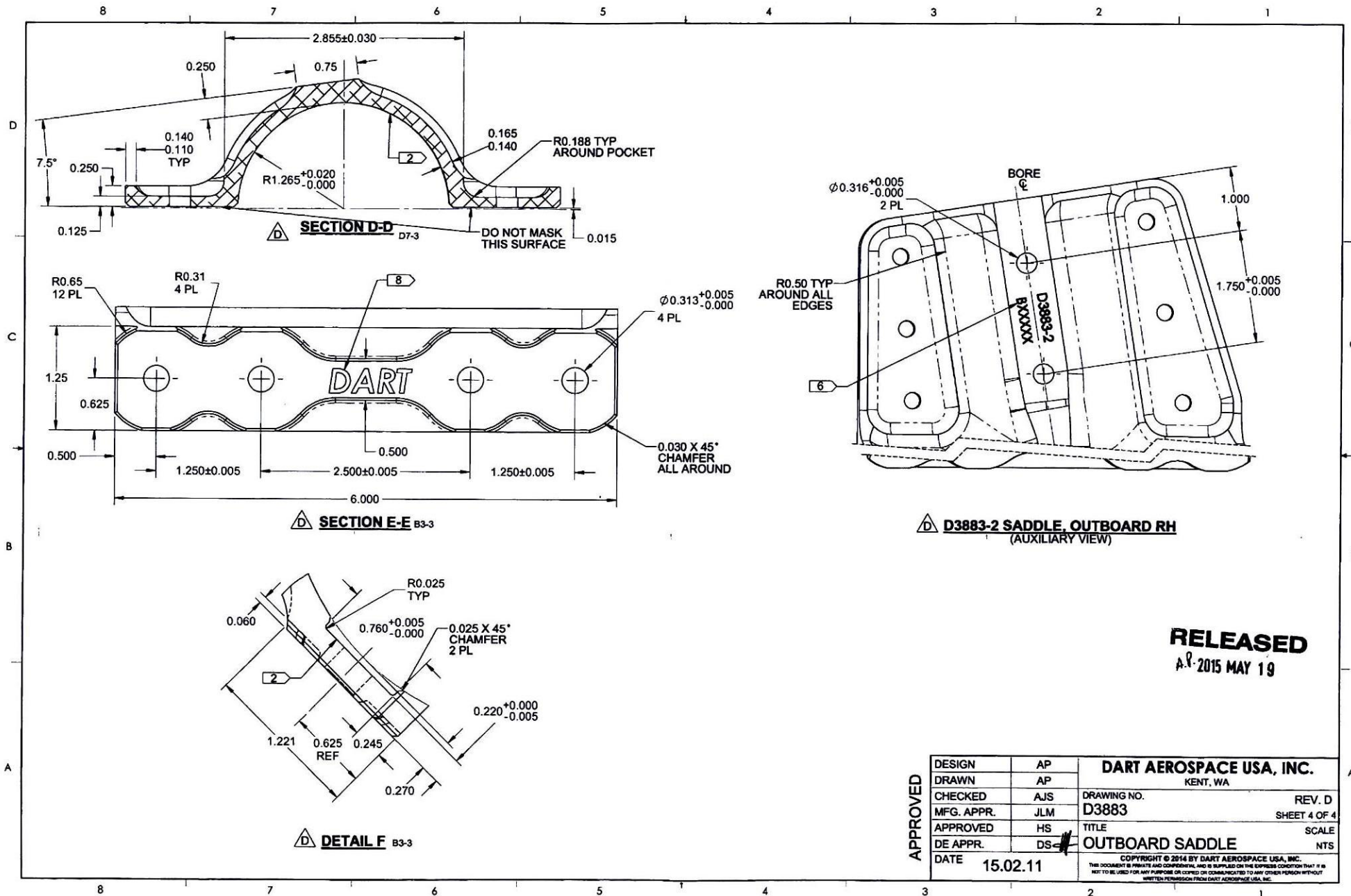
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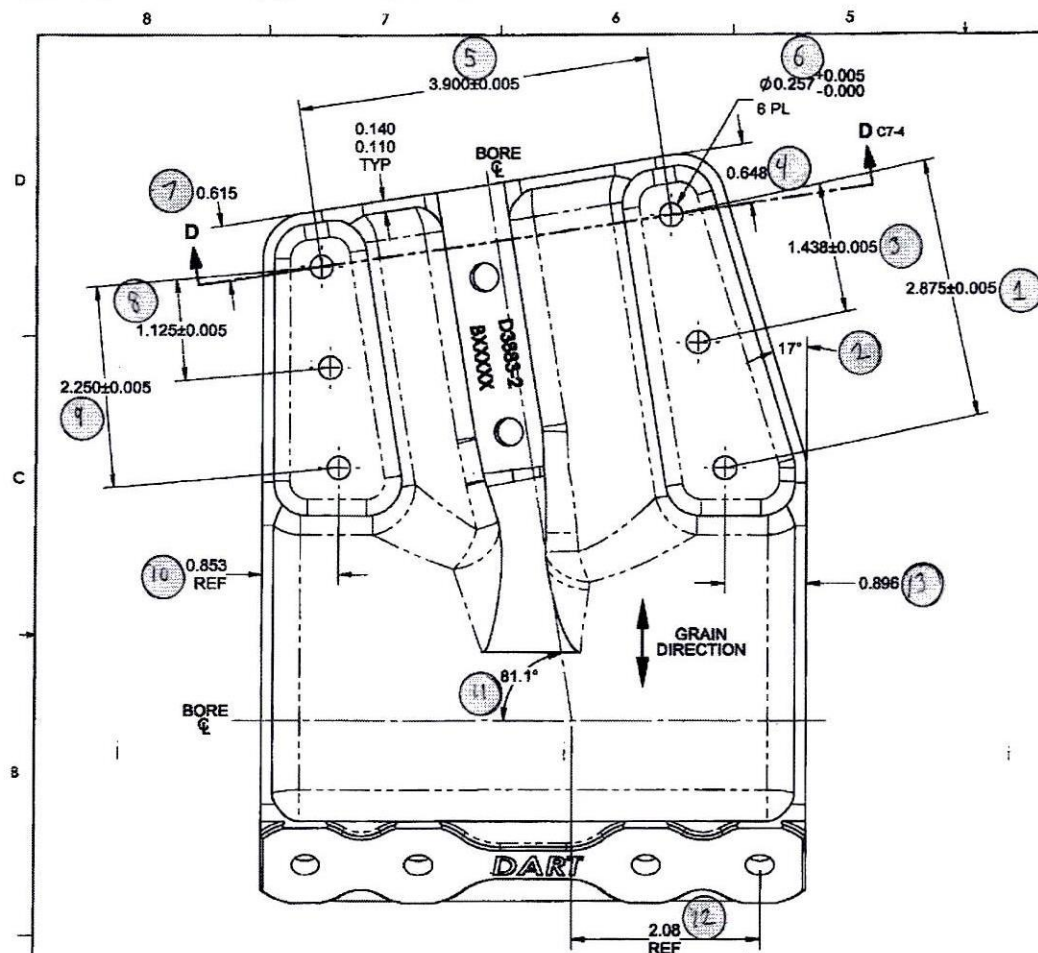
- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
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- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-2-REVD.SLDPRT"



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A.P. 2015 MAY 19

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	JLM	D3883	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD SADDLE	NTS
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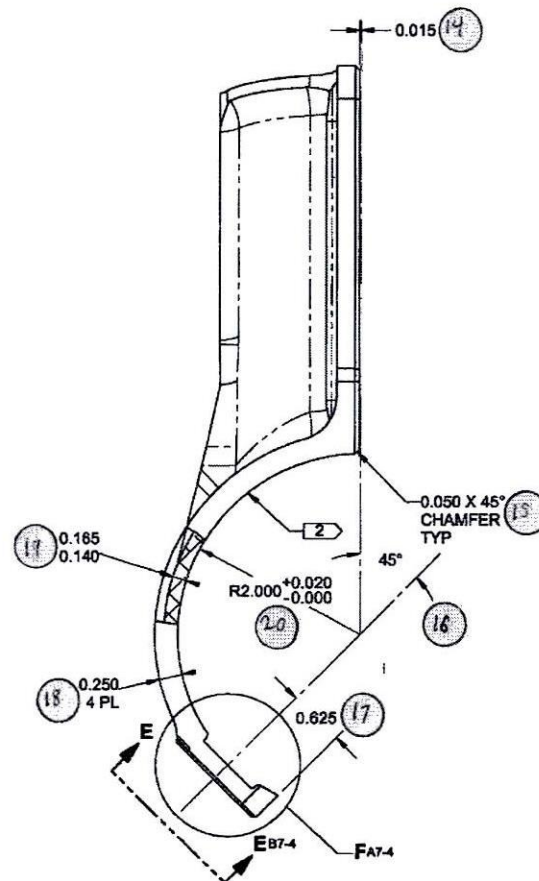




D3883-2 SADDLE, OUTBOARD RH

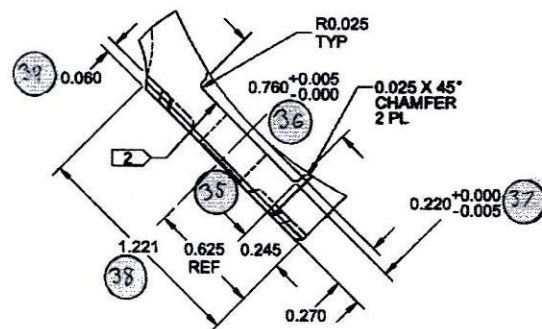
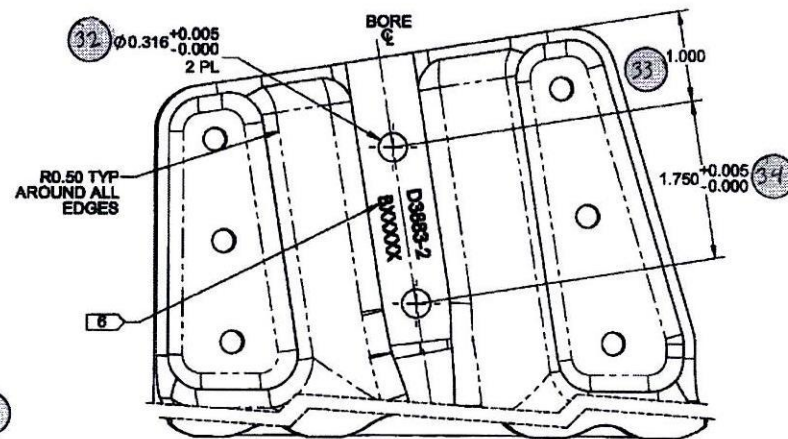
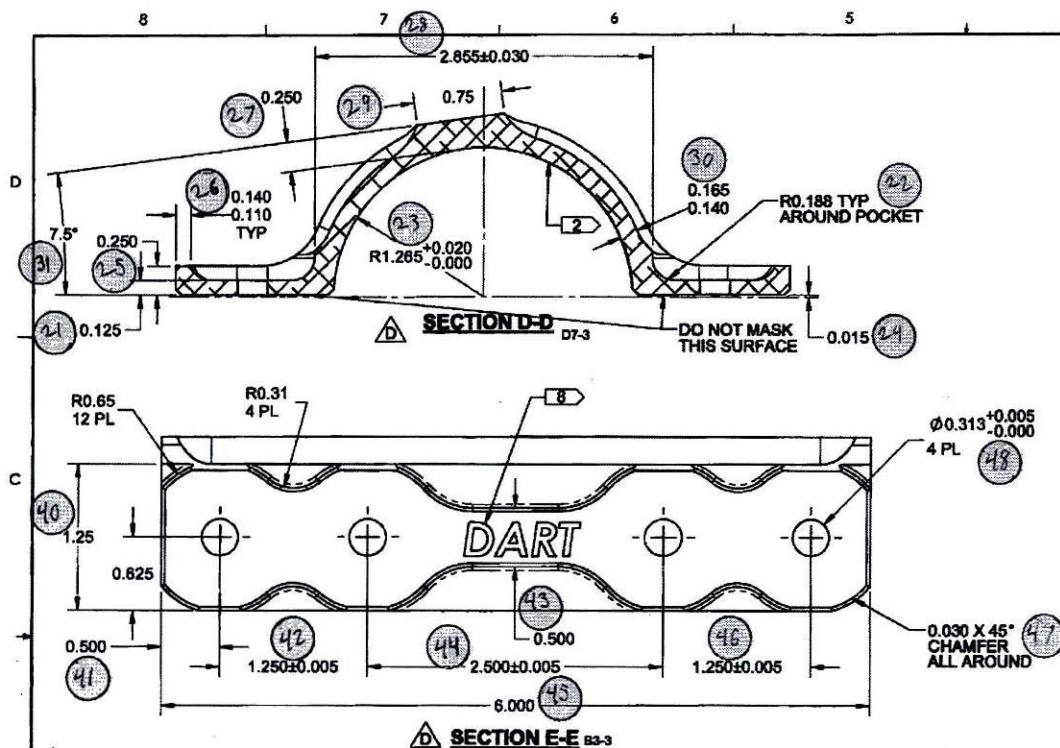
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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
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	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D3883	SHEET 3 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD SADDLE	NTS
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	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D3883	SHEET 4 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD SADDLE	NTS
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